

**Work Order ID 66303**

Wednesday, February 09, 2011 1:14:35 PM



Page 1

Item ID: D3391-021

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Tube Assembly

Start Date: 2/9/2011 Start Qty: 1.00

Required Date: 2/11/2011 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursTool ID Tool # Plan  
Code Accept Reject Reject Insp.  
Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D3391

Rev H

100

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

Cut extrusion to 46.52 +0.010 -0.020

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend I

Memo

0.00

CNC Delta 100 Bender

Bend as per Dwg D3391 Using Bend Prog 3391021

120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

DP

11-5-5

DP

11-5-5

11-05-09

RO

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3391-021 PAR #: N/A Fault Category: machining NCR: Yes No DQA: LS Date: 11.06.09  
 Resolution: use as in Disposition: use as in QA: N/C Closed: OK Date: 11/06/10

NCR: 66303		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11.5.6	130	1687 slot to far on one side by .020" over tol. ran wrong prog. <del>4.250</del> 4.250" dimension is 4.280". RC: LOP	11.05.10 OS1042	ACCEPTABLE DEVIATION. REF DIMENSION THAT DOESN'T AFFECT ANALYSIS	29.11.5.6	8 11.05.10 OS1042	11.06.06 OS1042	11.06.10 OS1042

NOTE: Date & initial all entries

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Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per Folio FA590 Rev. MA & Dwg D3391 Rev. 1A  
Identify as D3391-1  
2-Deburr

20 11-5-5

1

140

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

20 11-5-5

1

150

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Drill X1 Aft cap as per Dwg D3391 .1875" dia

20 11-05-07

1

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Required Date: 2/11/2011 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

QC:

Date:

Tooling:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

160



QC

Quality Control

Operation  
Description

QC2- Inspect parts off machine FAI/FAIB

Memo

Set Up/  
Run Hours

0.00

0.00

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

11-05-07

1 7

170



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

SL 11/05/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Cust Item ID:

Required Date: 2/11/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp,  
Stamp

180

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Drill float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size)  
(ONLY DRILL HOLES MARKED "A")

2-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875" holes drilled in previous step

3-Open tow cap holes to .208" as per Dwg D3391

4-Open Tow Ring hole to .640" as per Dwg D3391

5- open float bag holes 0.328" and counter sink as per dwg D3391

6-Deburr & Scribe Batch number Inside aft end.

7-Transfer drill D3391-021 with D3391-023

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

5/1/09/19







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Item ID: D3391-021

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Setup Start



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Cust Item ID:

Required Date: 2/11/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.  
Code Qty Qty Number Stamp

200

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

IX m-f 11/05/24

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 BR 11-5-24,

220

Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

1-instal spacers as per dwg D3391  
A/R Magnabond 6398 batch: M116677  
exp. date: 08/2011  
cure time 12hrs. as per QSI015  
2- grind crossbolt flush  
3-back drill crossbolt if necessary

02-11/05/24

1 8 BE 11/05/25



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Setup Start



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Start Date: 2/9/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/11/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

230



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8 11/05/126

235



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

Memo

0.00

AND REALODINE AS PER PAR09-043

1 0 11/05/126

240



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

0.00

START TIME: 1:30

OVEN TEMPERATURE: 320°

FINISH TIME: 2:00

1 BL 11-5-26-



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Required Date: 2/11/2011 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

250



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

255



Skidtubes

Skidtubes

Skidtubes

Memo

\*\*\*\* install D3591-1 spacer as per DS19364 and wearplate and gasket as per DWG \*\*\*\*

0.00

0.00

257



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/11/05/31

(40)

16 24 11/05/30





# Work Order ID 66303

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Item ID: D3391-021  
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Start Date: 2/9/2011 Start Qty: 1.00  
Required Date: 2/11/2011 Req'd Qty: 1.00  
Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:  
QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

260

Identify as per dwg & Stock Location: W10

0.00 0412-742-043/BG4981

1 0 41 11/05/30



Packaging

Memo

0.00

Packaging

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/31 AJ  
MF  
11-05-31





# Picklist Print

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Page 1

Work Order ID: 66303

Parent Item: D3391-021

Parent Item Name: Fwd Tube Assembly



Start Date: 2/9/2011

Required Date: 2/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A: 05.09.13 New issue: KJ/ILM  
 IPP B: 06.02.10 Dwg rev.D ecn 773 :EC:  
 IPP C: 06.05.02 Added inspections :EC:  
 IPP D: 07.03.13 rev F dwg EC  
 IPP E: 07.11.07 revG dwg ecn1053P EC verified by: DD  
 IPP Rev:f ECN 1056 07-11-12 DD verified by: EC  
 IPP Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC  
 IPP Rev:H 08-09-10 revH as per dwg DD verified by:EC  
 IPP Rev J 09.02.02 added hardware EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6013-047



Skidtube Material

Manufactured

No

100

Each

31.0000

1

1

Location

Loc Qty

Loc Code

LG

31

23935

3

26547

28

D3670-4-200



SPACER

Manufactured

No

220

Each

71.0000

4

4

Location

Loc Qty

Loc Code

LG

71

57349

19

63317

12

66041

40

D3401-041



Tow Cap Assembly

Manufactured

No

255

Each

11.0000

1

1

Location

Loc Qty

Loc Code

FP

11

46029

10

50316

1

BG1505

x1

0 DP 11-5-5

BE 11/05/28  
 B 68107

M 11/05/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 2

Work Order ID: 66303

Parent Item: D3391-021

Parent Item Name: Fwd Tube Assembly

Start Date: 2/9/2011

Required Date: 2/11/2011

Start Qty: 1.00



Required Qty: 1.00

D3564-13 Manufactured No 255 Each 11.0000 1 1  
  
 Wearshoe  *all u/05/30*

Location	Loc Qty	Loc Code
FP17	11	B66136
59660	1	
62229	10	

D3566-13 Manufactured No 255 Each 21.0000 1 1  
  
 Gasket  *all u/05/30*

Location	Loc Qty	Loc Code
FP012	1	
61996	1	
FP014	20	B68341
64070	20	

AN960C10L NAS1149C0332 Purchased No 255 Each 25.0000 10 10  
  
 washer  *all u/05/30*

Location	Loc Qty	Loc Code
ST245	25	M117291
107534	25	

AN3C4A Purchased No 255 Each 1.680.000 10 10  
  
 BOLT 

Location	Loc Qty	Loc Code
ST350	1680	
115300	25	M117313
116075	571	
116590	84	
116704	1000	

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Shop Packet Print

Page 2

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

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Page 3

Work Order ID: 66303

Parent Item: D3391-021

Parent Item Name: Fwd Tube Assembly



Start Date: 2/9/2011

Required Date: 2/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3672-1 Manufactured No

255

Each

1.153.000

4

4



Phenolic Washer



u105630

## Location

## Loc Qty

## Loc Code

ST077

1153

42329

10

52505

143

64177

1000

AELS-1032-130 Purchased No

255

Each

0.0000

2

2



INSERT

M 117331



x2) u105630

AELS-1032-225 Purchased No

255

Each

0.0000

10

10



INSERT

M 110768



x10) u105630

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Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

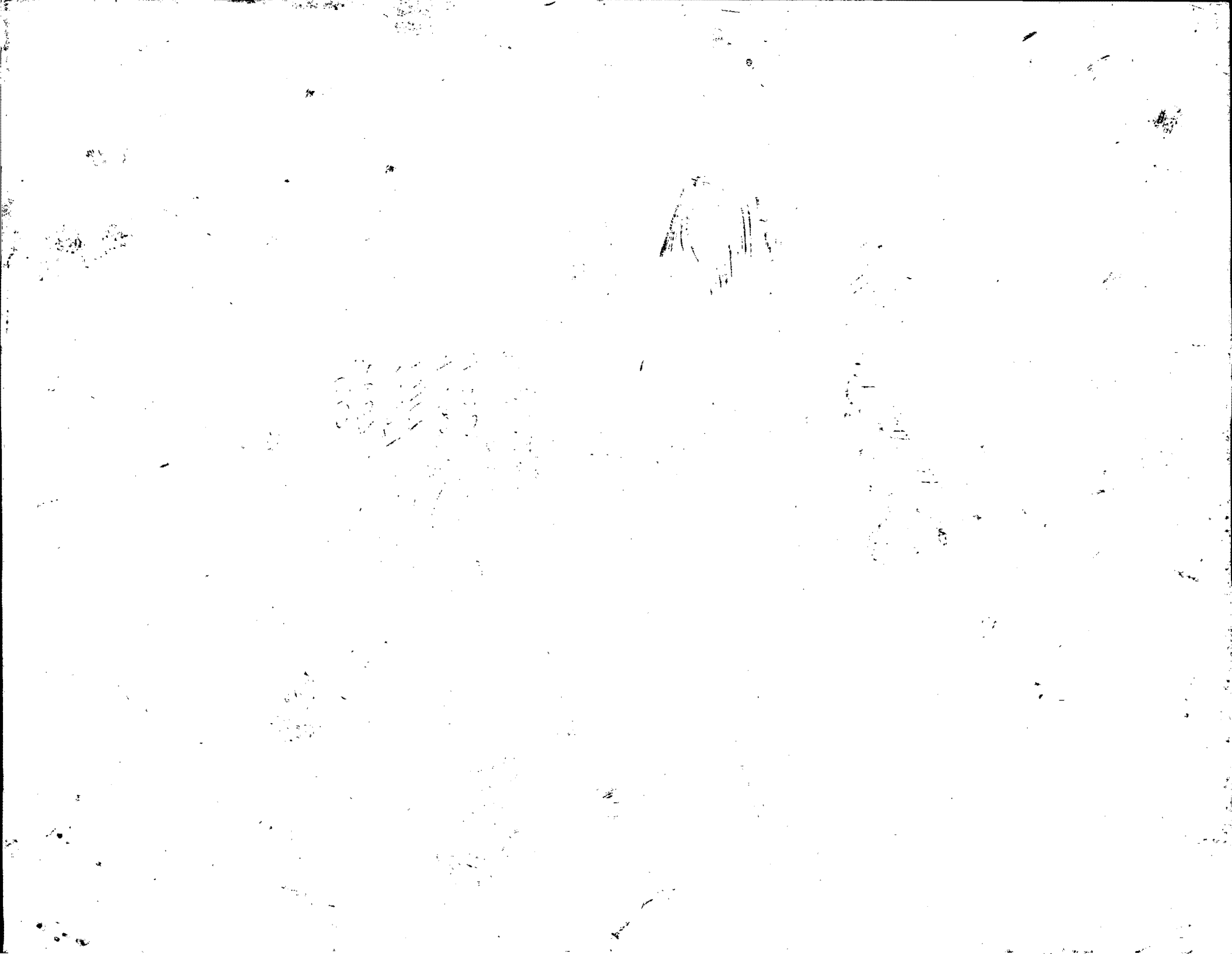
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

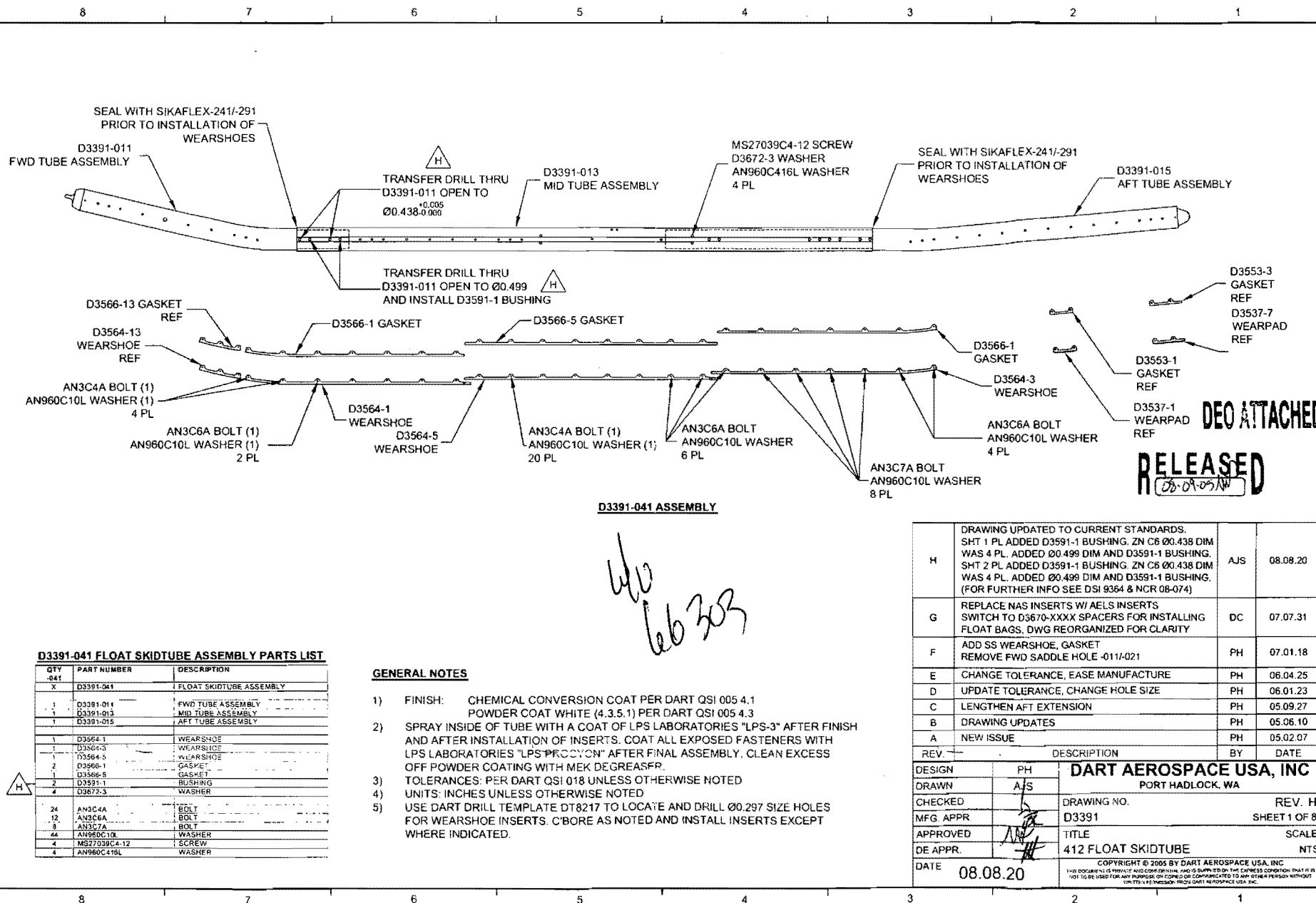
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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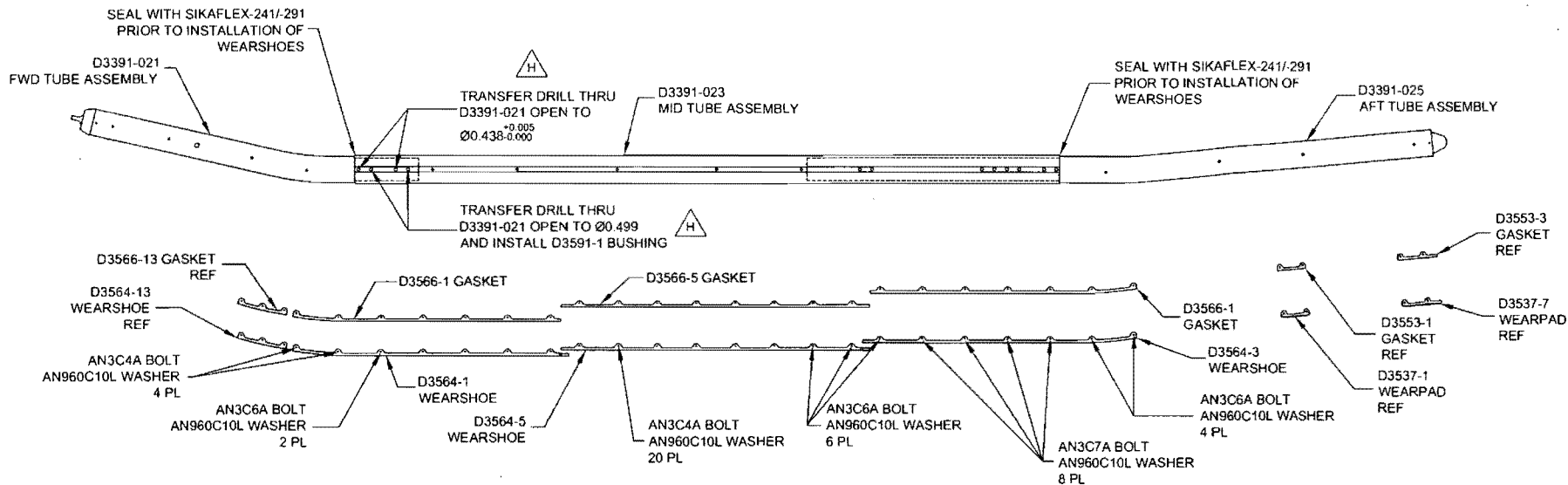












**D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST**

QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
2	D3566-13	GASKET
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER

**GENERAL NOTES**

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.291 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

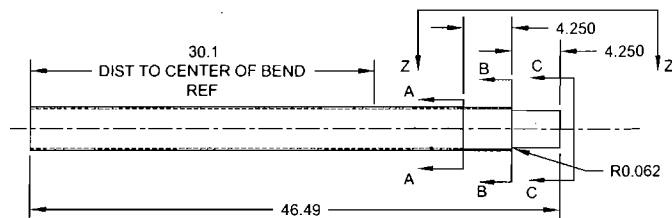
66303

DEO ATTACHED

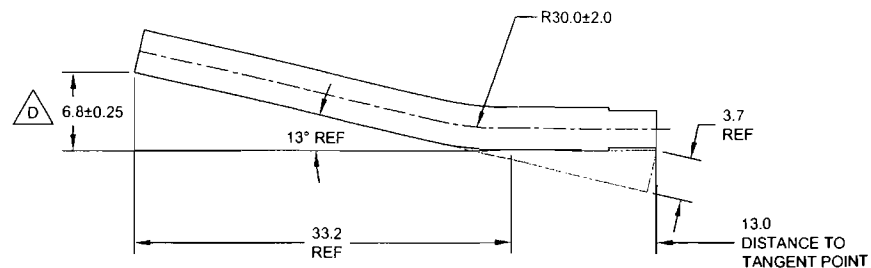
RELEASED  
08-09-05/10

DESIGN	PH	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG APPR.		D3391	SHEET 2 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE BASIS OF CONFIDENTIALITY. IT IS NOT TO BE USED FOR ANY PURPOSES OR CONTAINED OR COPIED FOR THE USE OF ANY OTHER PERSON OR ENTITY WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

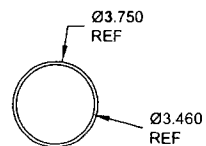
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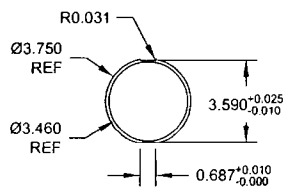
**D3391-1 CUTTING DETAIL**  
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



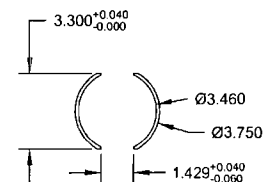
**D3391-011/-021 BENDING DETAIL**  
(MAKE FROM D3391-1)



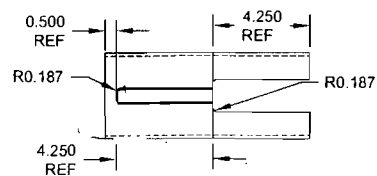
**SECTION A-A**  
SCALE 2X



**SECTION B-B**  
SCALE 2X



**SECTION C-C**  
SCALE 2X



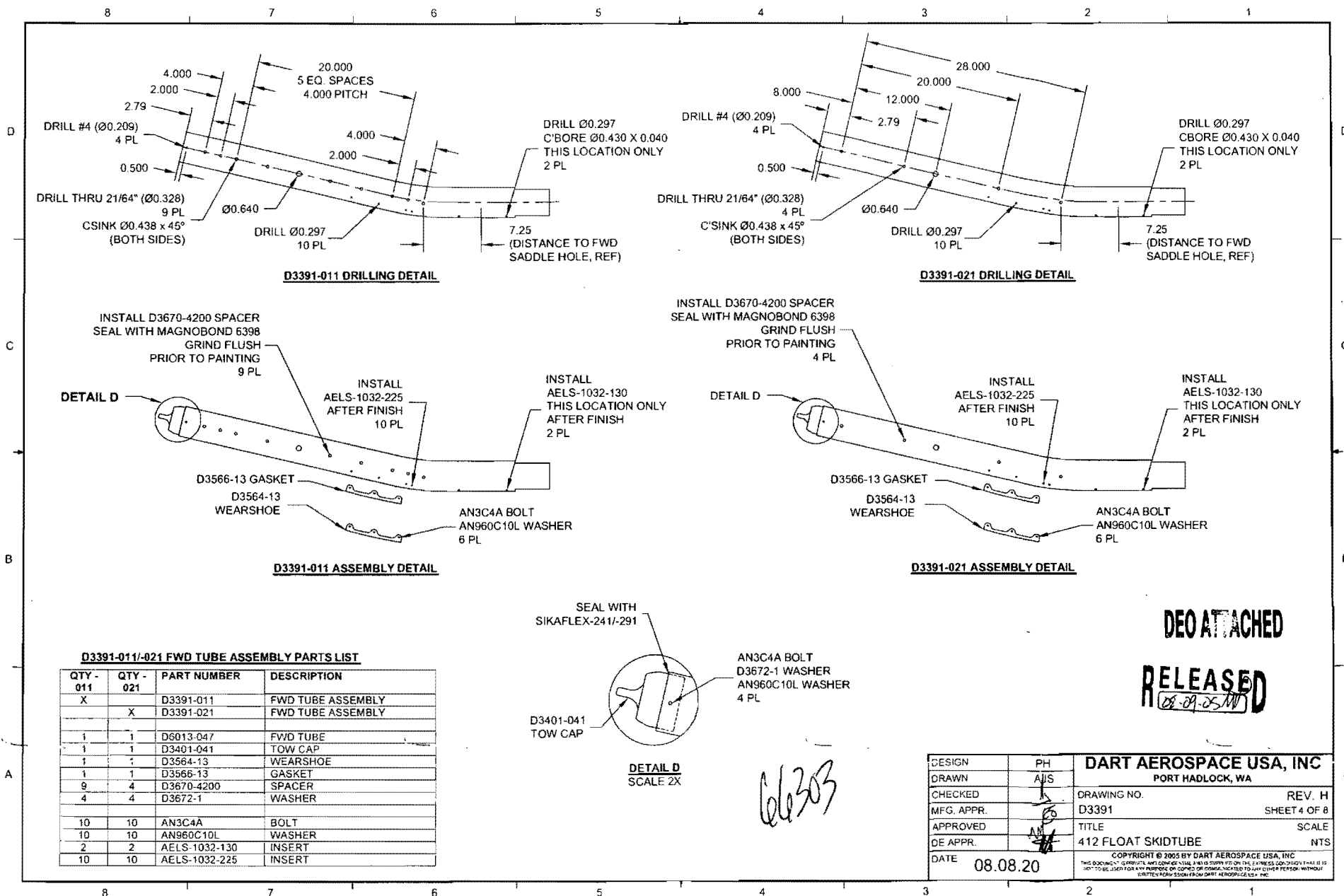
**VIEW Z-Z**  
SCALE 2X

46303

DEO ATTACHED  
RELEASED  
28 JAN 05 NW

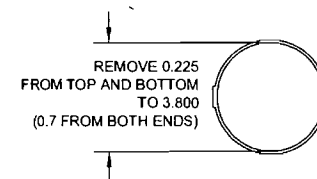
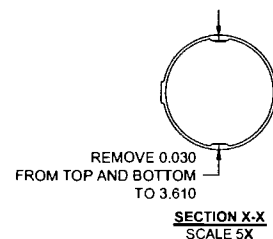
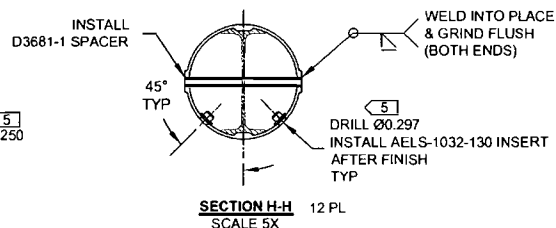
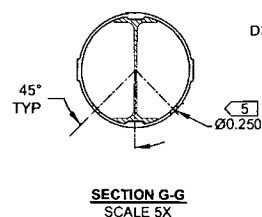
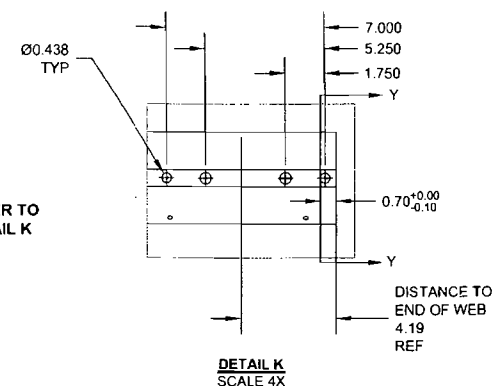
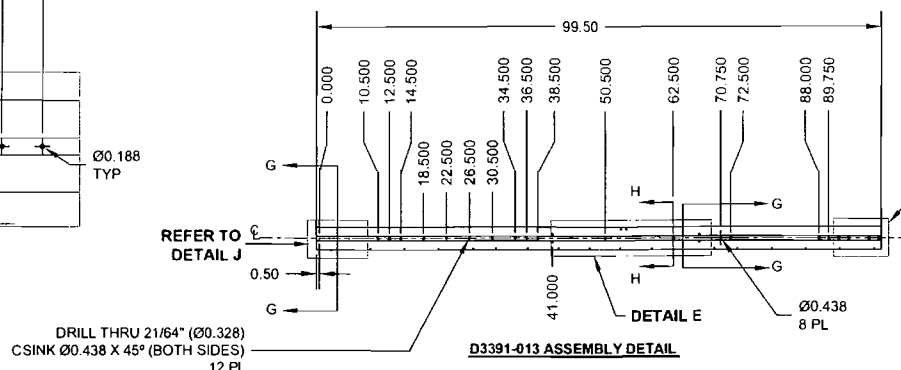
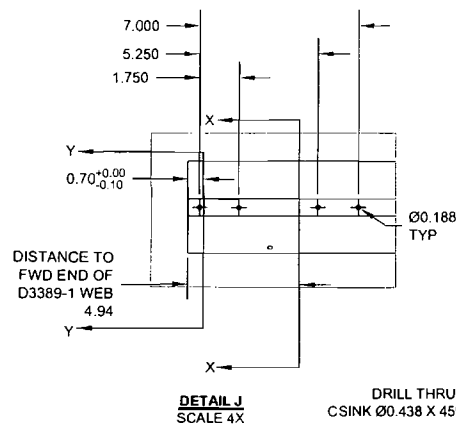
DESIGN	PH	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AUS	PORT HADLOCK, WA	
CHECKED		DRAWING NO. D3391	REV. H SHEET 3 OF 8
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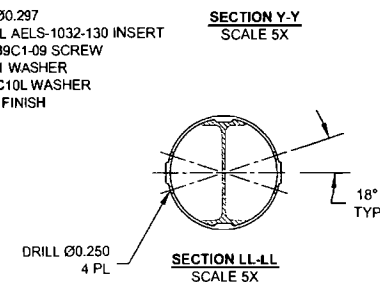
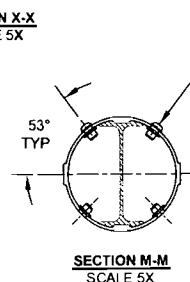
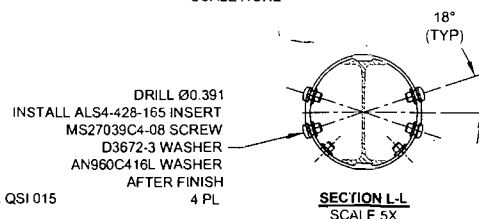
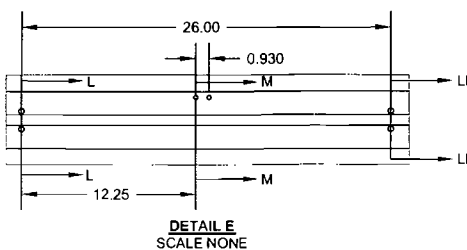


#### D3391-013 MID TUBE ASSEMBLY PARTS LIST

QTY -013	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW

#### D3391-013 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

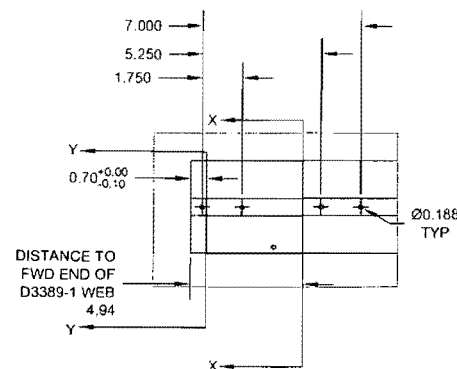


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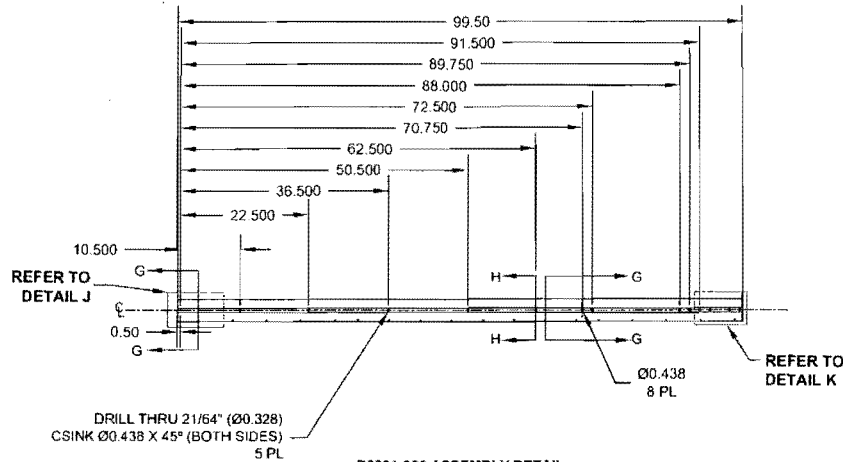
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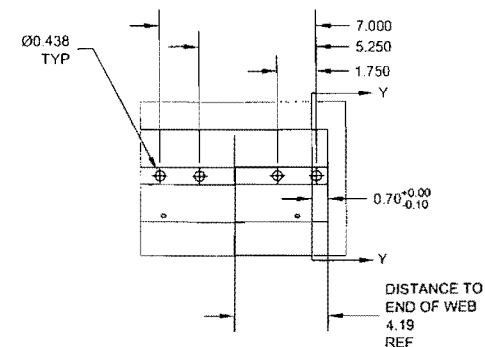




DETAIL J  
SCALE 4X



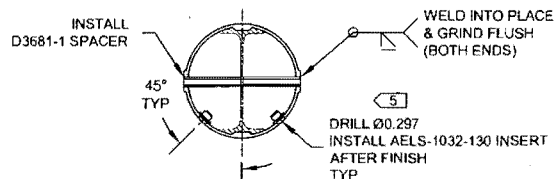
D3391-023 ASSEMBLY DETAIL



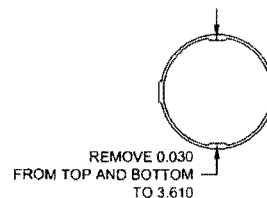
DETAIL K  
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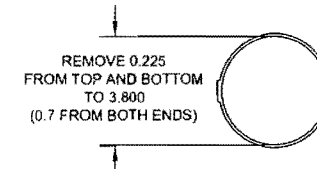
SECTION G-G  
SCALE 5X



SECTION H-H  
SCALE 5X



SECTION X-X  
SCALE 5X



SECTION Y-Y  
SCALE 5X

D3391-023 MID TUBE ASSEMBLY PARTS LIST

QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

D3391-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

DEO ATTACHED

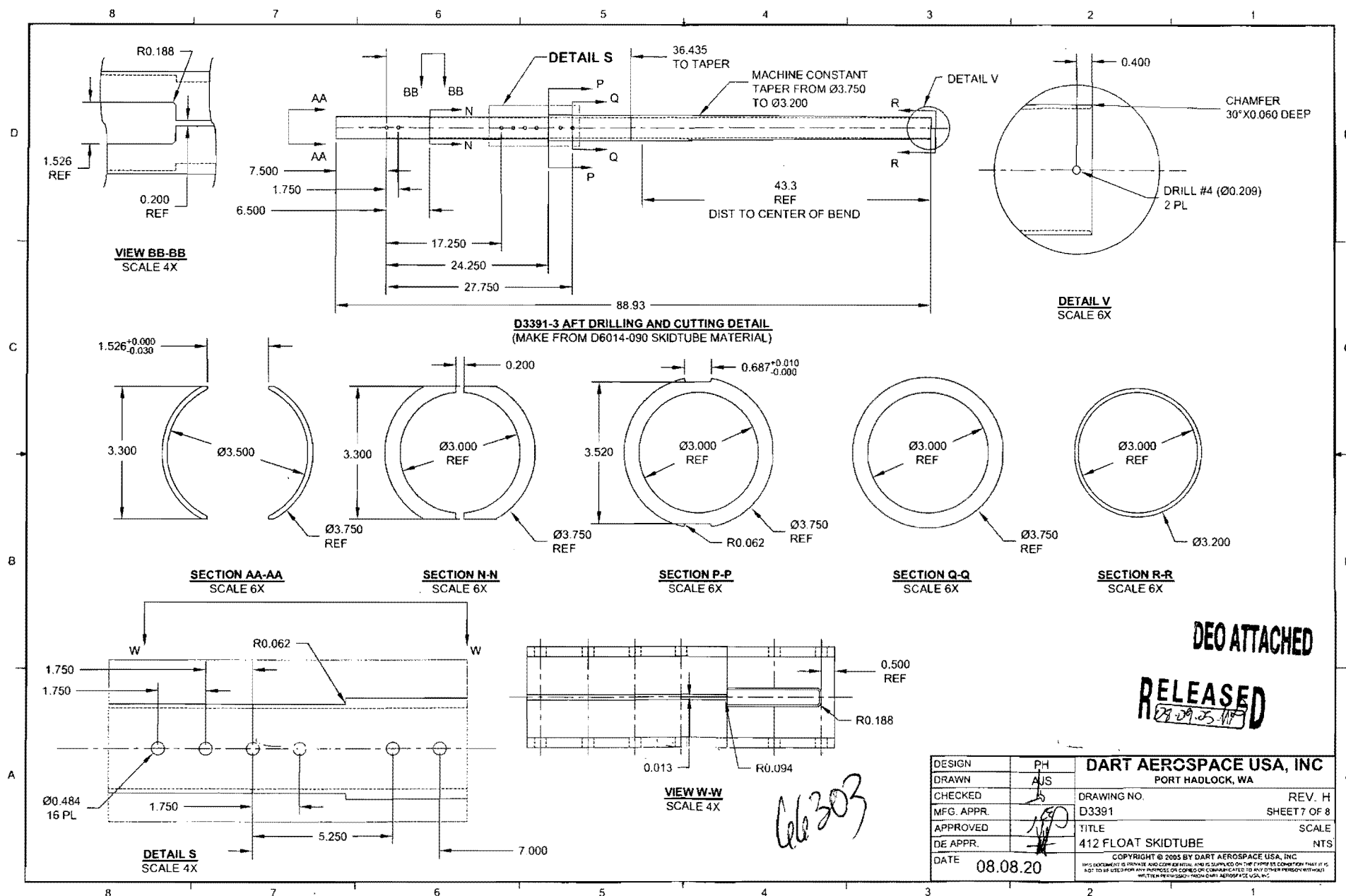
RELEASED  
08-08-20

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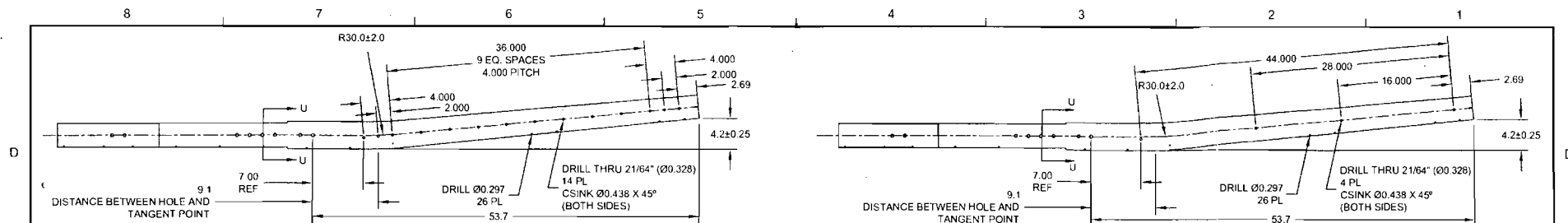
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MFG. APPR.		D3391 SHEET 6 OF 8
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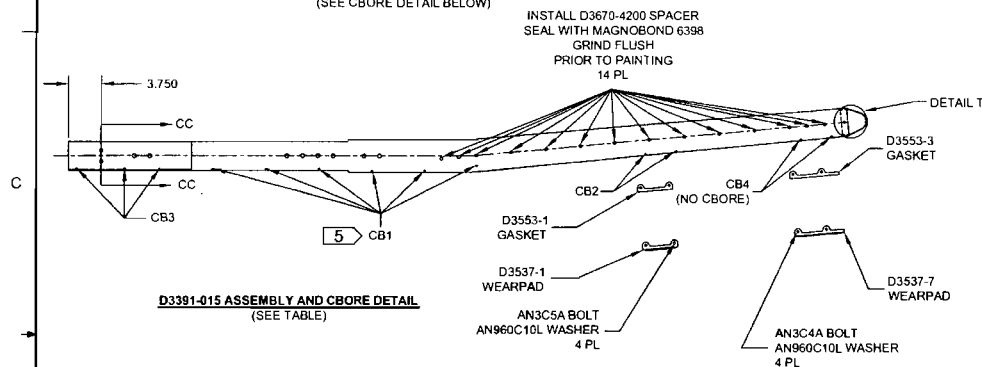




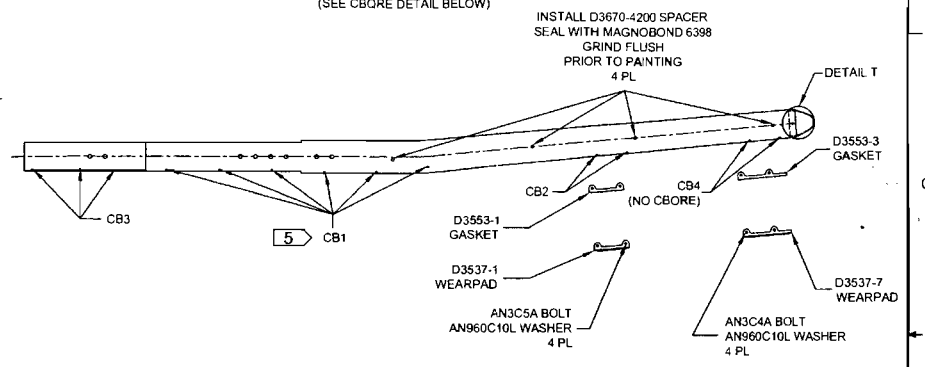


**D3391-015 BENDING AND DRILLING DETAIL**  
(SEE CBORE DETAIL BELOW)

**D3391-025 BENDING AND DRILLING DETAIL**  
(SEE CBORE DETAIL BELOW)



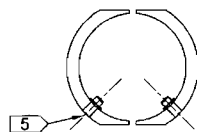
**D3391-015 ASSEMBLY AND CBORE DETAIL**  
(SEE TABLE)



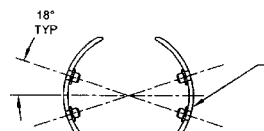
**D3391-025 ASSEMBLY AND CBORE DETAIL**  
(SEE TABLE)

**D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST**

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X		D3391-015	AFT TUBE ASSEMBLY
	X	D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
1	1	D3537-1	WEARPAD
1	1	D3537-7	WEARPAD
1	1	D3553-1	GASKET
1	1	D3553-3	GASKET
14	4	D3670-4200	SPACER
2	2	D3672-1	WASHER
14	14	AELS-1032-130	INSERT
12	12	AELS-1032-225	INSERT
4		ALS4-428-165	INSERT
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
10	10	AN960C10L	WASHER

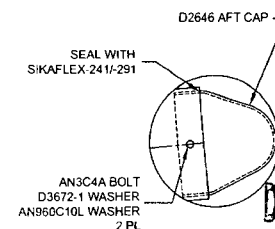


**SECTION U-U**  
SCALE 3X



**SECTION CC-CC**  
SCALE 3X

DRILL Ø0.391  
CBORE Ø0.516 X 0.040 DEEP  
INSTALL ALS4-428-165 INSERT  
4 PL



**DETAIL T**  
SCALE 4X

CBORE HOLES MARKED CB1-CB4 AS FOLLOWS AND  
INSTALL AELS-1032-XXX AFTER FINISH AS NOTED

HOLES MARKED	QTY D3391-015	QTY D3391-025	CBORE	P/N
CB1	12	12	Ø0.430 X 0.170	AELS-1032-225
CB2	4	4	Ø0.430 X 0.170	AELS-1032-130
CB3	6	6	Ø0.430 X 0.040	AELS-1032-130
CB4	4	4	NONE	AELS-1032-130

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**RELEASED**  
08-09-05-140

W6303





DRAWING NO. D3391	TITLE 412 FLOAT SKIDTUBE	REV. H	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3391-H-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>MP</i>	CHECKED <i>h</i>	MFG. APPR. <i>AS</i>	APPROVED <i>MP</i>		DE APPR. <i>h</i>		
DATE 09.09.23	DATE 09.09.24	DATE 09/09/25	DATE 09/09/30		DATE 09/09/30		

**PURPOSE:**

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

**CHANGE:**

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

- 2) ~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH~~  
~~AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH~~  
 LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS  
 OFF POWDER COATING WITH MEK DEGREASER.

**RELEASED**  
 2010-02-02

*MP*

*W303*

